

Date: Wednesday, 5/10/2006 9:17:17 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350/212/130 BASKET LID
Job Number :	27047B		
Estimate Number :	10193		
P.O. Number :	N/A	Part Number :	D2512
This Issue :	5/10/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2512 REV D2
First Issue :	N/A	Project Number :	N/A
Previous Run :	26844B	Drawing Revision :	D2
		Material :	N/A
Written By :	Due Date :		5/30/2006
Checked & Approved By :	Qty:		1 Um: Each
Comment :	Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: M100138

M100023 → 61.68"

M119557 → 95.52"

M100704 → 51"

M100748 → 282.49"

CPL 06.05.10

2.0

D31663

Basket Hoop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3166-3

Basket Hoop

B25896

CPL 06.05.10

3.0

D2506

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2506

Label Plate

B26631

CPL 06.05.10

4.0

D23271

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-1

Bushing

B24873

CPL 06.05.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/10/2006 9:17:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27047B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

325238

CPL 06.05.10

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

326204

CPL 06.05.10

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M100981

CPL 06.05.16

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

CPL 06.05.17

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

~~4-D2012-117 is included in D3172-041 EC130 Basket Base BOM.
EC130 Basket only~~

~~Pick:~~

~~Qty Part Number~~

~~Description~~

~~Batch~~

~~2 D2012-117 Clevis~~

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/29

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/10/2006 9:17:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27047B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

RD

06-05-18

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/23 ①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M100652 FC 06 05 23

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-05-25 ①

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

DLA u

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/05/23 ①

Job Completion



u 06/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

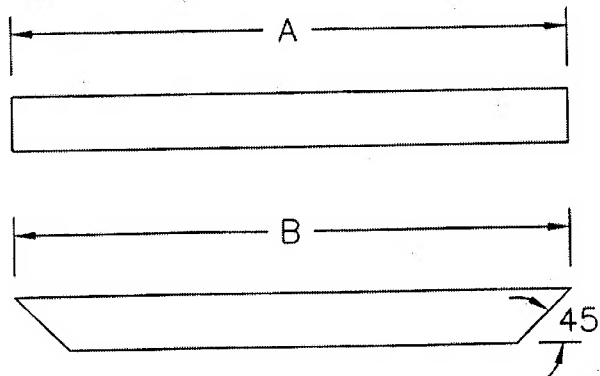


DESIGN BW	DRAWN BY JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED JP	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	
A		95.11.21	NEW ISSUE
B		96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C		99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D		01.04.19	CHANGE HINGE
D1		JP 03.01.20	ADD D2012-117 FOR D130-701-041
D2		JP 04.09.20	TACK WELD ANT-SKID AREA

RELEASED
01.04.27 JP

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

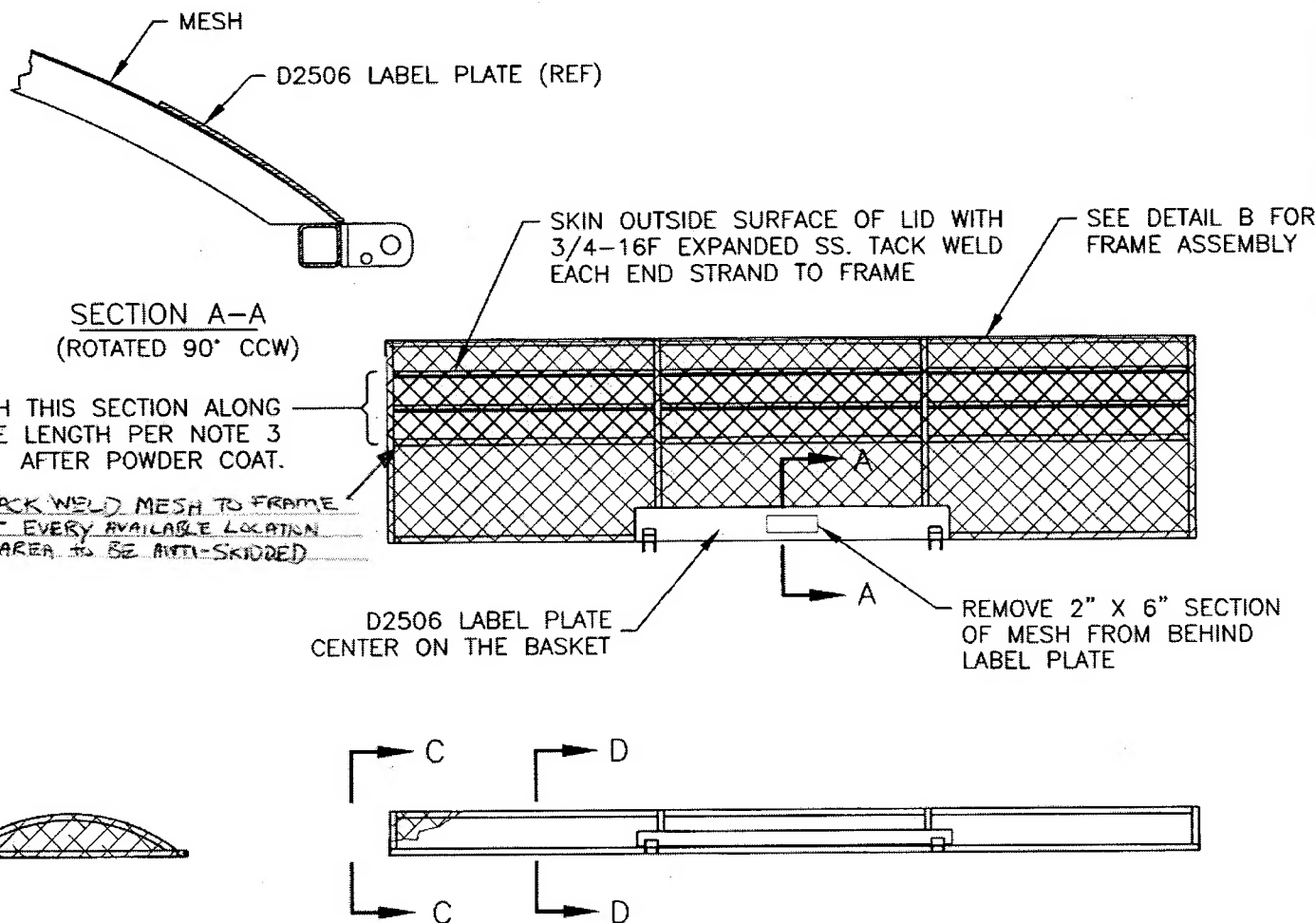
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DART



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CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	01.04.19	TITLE	D2512	REV. D
				SHEET 2 OF 4
				SCALE
				1:20



D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

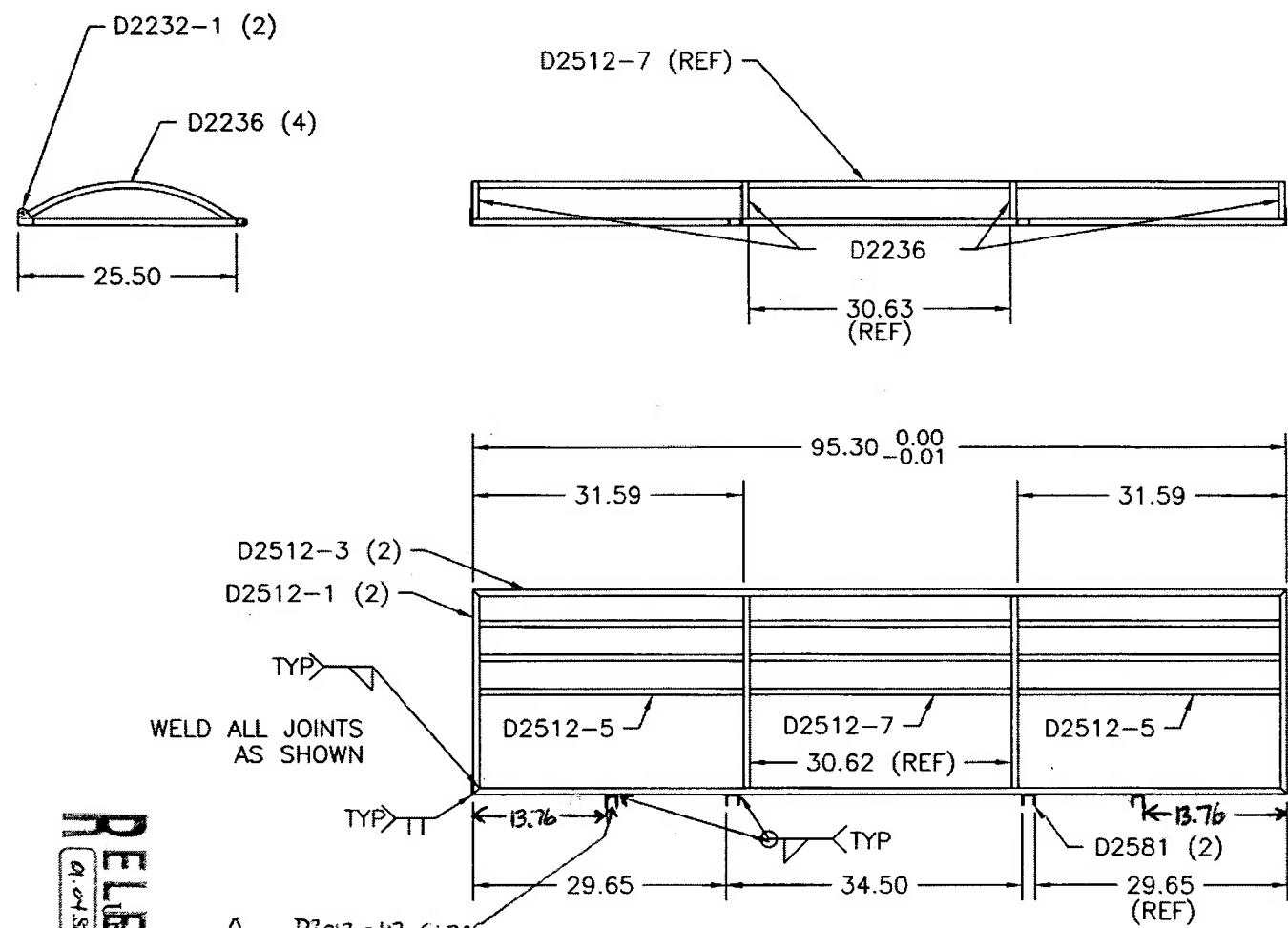
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CHECKED	APPROVED	DRAWING NO.
01.04.19		D2512
DATE	TITLE	REV. D
	BASKET LID ASSEMBLY (350/212)	SHEET 3 OF 4
		SCALE
		1:20

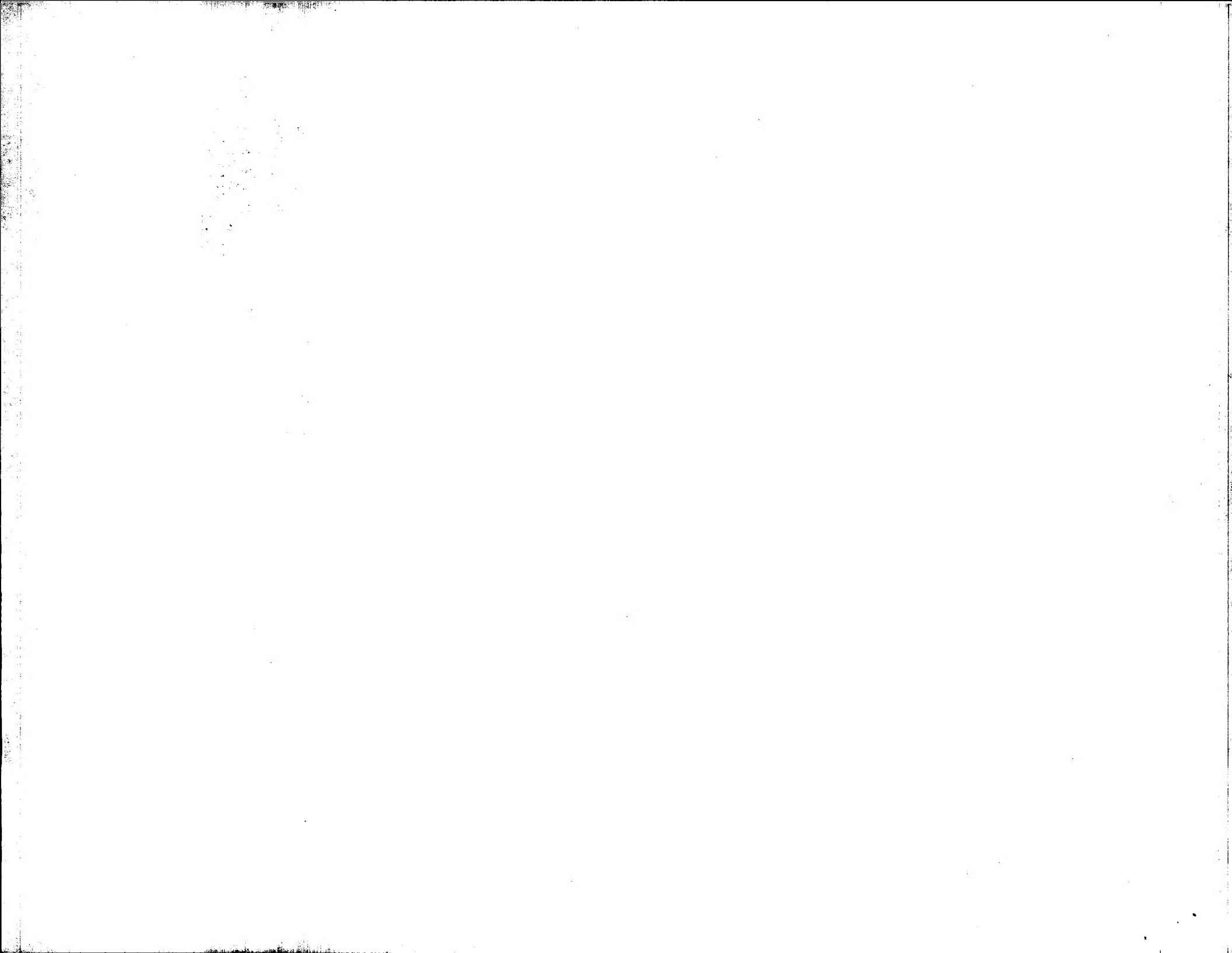


DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D2012-117 CLEMS
ADD FOR D130-701-041
ONLY (2 PLACES)

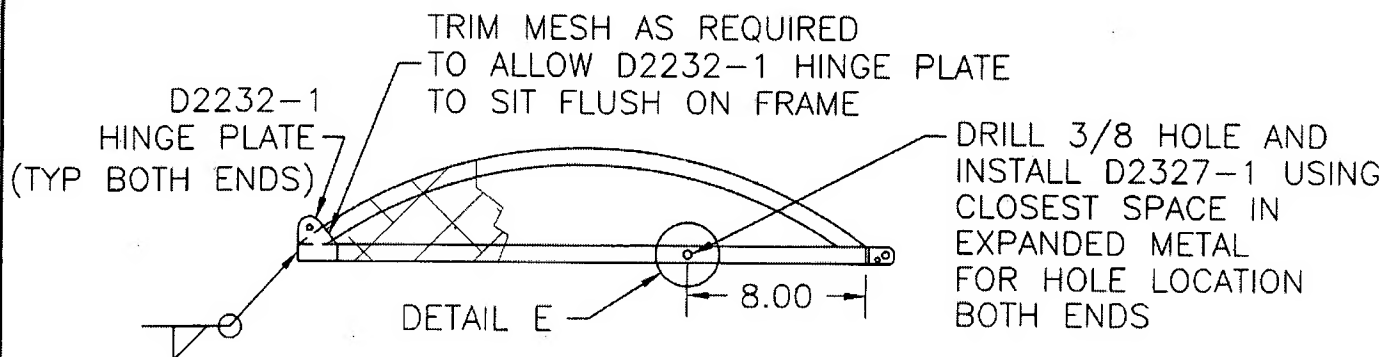
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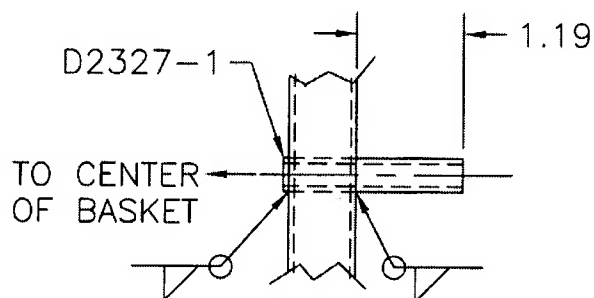




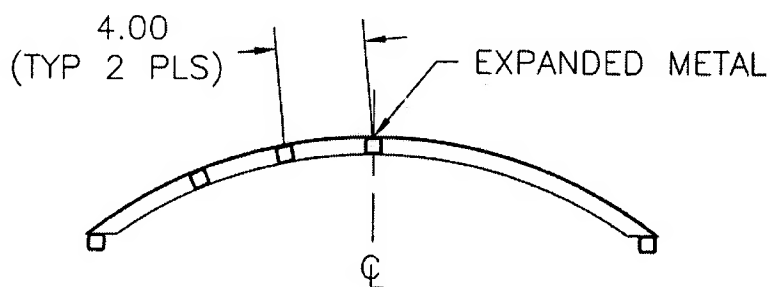
DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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